

PCT

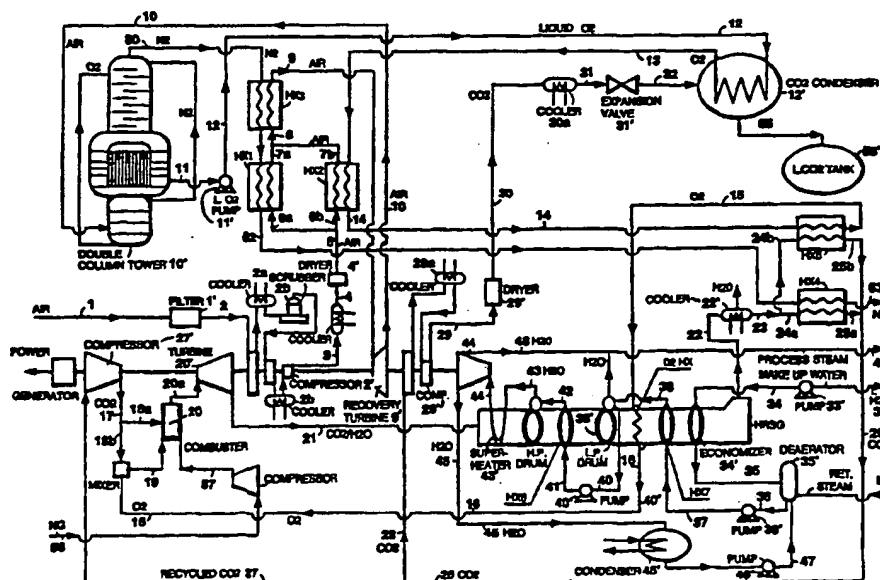
WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : F02C 6/00	A1	(11) International Publication Number: WO 97/07329 (43) International Publication Date: 27 February 1997 (27.02.97)
(21) International Application Number: PCT/US95/11018 (22) International Filing Date: 23 August 1995 (23.08.95) (30) Priority Data: 08/517,542 21 August 1995 (21.08.95) US (71) Applicant: UNIVERSITY OF MASSACHUSETTS MEDICAL CENTER [US/US]; 55 Lake Avenue North, Worcester, MA 01655 (US). (72) Inventors: GOLOMB, Dan, S.; 61 Plainfield Street, Newton, MA 02168 (US). SHAO, Yulin; 35 Lincoln Street, Stoneham, MA 02180 (US). BROWN, Gilbert, J.; 14 Hidden Valley Road, Westford, MA 01886 (US). (74) Agent: FASSE, Peter, J.; Fish & Richardson P.C., 225 Franklin Street, Boston, MA 02110 (US).		(81) Designated States: AU, CA, FI, JP, KP, KR, NO, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published With international search report.

(54) Title: POWER PLANT WITH CARBON DIOXIDE CAPTURE



(57) Abstract

The invention relates to a power plant including an air separation unit (10') arranged to separate oxygen from air and produce a stream of substantially pure liquid oxygen; a gas turbine (20') arranged to combust fuel in the presence of substantially pure oxygen gas and carbon dioxide, and to produce exhaust gas comprising water and carbon dioxide; and a carbon dioxide removal unit (12', 22') arranged to recover carbon dioxide from the exhaust gas, recycle a portion of the carbon dioxide through the gas turbine, and liquify the remainder of the carbon dioxide for removal from the plant.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AM	Armenia	GB	United Kingdom	MW	Malawi
AT	Austria	GE	Georgia	MX	Mexico
AU	Australia	GN	Guinea	NE	Niger
BB	Barbados	GR	Greece	NL	Netherlands
BE	Belgium	HU	Hungary	NO	Norway
BF	Burkina Faso	IE	Ireland	NZ	New Zealand
BG	Bulgaria	IT	Italy	PL	Poland
BJ	Benin	JP	Japan	PT	Portugal
BR	Brazil	KE	Kenya	RO	Romania
BY	Belarus	KG	Kyrgyzstan	RU	Russian Federation
CA	Canada	KP	Democratic People's Republic of Korea	SD	Sudan
CF	Central African Republic	KR	Republic of Korea	SE	Sweden
CG	Congo	KZ	Kazakhstan	SG	Singapore
CH	Switzerland	LI	Liechtenstein	SI	Slovenia
CI	Côte d'Ivoire	LK	Sri Lanka	SK	Slovakia
CM	Cameroon	LR	Liberia	SN	Senegal
CN	China	LT	Lithuania	SZ	Swaziland
CS	Czechoslovakia	LU	Luxembourg	TD	Chad
CZ	Czech Republic	LV	Latvia	TG	Togo
DE	Germany	MC	Monaco	TJ	Tajikistan
DK	Denmark	MD	Republic of Moldova	TT	Trinidad and Tobago
EE	Estonia	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	UG	Uganda
FI	Finland	MN	Mongolia	US	United States of America
FR	France	MR	Mauritania	UZ	Uzbekistan
GA	Gabon			VN	Viet Nam

- 1 -

POWER PLANT WITH CARBON DIOXIDE CAPTURE

Background of the Invention

5 The invention relates to an improved combined cycle power plant, i.e., an electrical power generating plant, with complete carbon dioxide (CO₂) recovery. The plant emits essentially no pollutants, and achieves a high thermal efficiency.

10 Environmental pollution stemming from fossil-fueled power plants is of worldwide concern. Power plants emit air pollutants that may be toxic, e.g., toxic metals and polyaromatic hydrocarbons; precursors to acid rain, e.g., sulfur oxides (SO_x) such as sulfur dioxide
15 (SO₂), and nitrogen oxides (NO_x); precursors to ozone such as NO₂ and reactive organic gases; particulate matter; and greenhouse gases, notably CO₂. Power plants also discharge potentially harmful effluents into surface and ground water, and generate considerable amounts of solid
20 wastes, some of which may be hazardous.

 Although certain methods and technologies are being developed that reduce emissions and effluents, they are often expensive and require considerable energy. For example, the use of natural gas (NG) as a fuel instead of
25 petroleum or coal reduces many emissions and solids wastes; however, burning NG in air still produces copious quantities of NO₂, reactive organic gases, and CO₂.

 This CO₂ can be "captured" or removed from the flue gas using several known methods including air
30 separation/ flue gas recycling, amine scrubbing, cryogenic fractionation, and membrane separation. Among these methods, air separation/flue gas recycling is considered to be the most cost and energy efficient, although amine scrubbing is a close competitor.
35 Nevertheless, all of these methods significantly impair

- 2 -

the efficiency of the power plants in which they are used.

Flue gas recycling is also used to lower the combustion temperatures in the power plant's gas turbines. This is beneficial because the combustion of a hydrocarbon in pure oxygen yields a much higher temperature than combustion in air. While this higher temperature improves the thermodynamic efficiency of the heat engine, present materials used in combustors, boilers, and gas turbines cannot withstand these high temperatures. Flue gas recycling can lower the combustion temperature to tolerable values. However, as noted above, the flue gas recycling as presently implemented significantly decreases the overall efficiency of the power plant.

A conceptual design of a natural gas-fired power plant with CO₂ capture is described in Suzuki et al., Proc. Int'l Symp. on CO₂ Fixation and Efficient Utilization of Energy, Tokyo Inst. Tech., Tokyo, Japan, pp. 57-64 (1993). The net efficiency of this plant was estimated to be 40.7 percent. Akiya et al., Proc. 26th Intersoc. Energy Convers. Energy Conf., 6:109 (1991), describes a liquid natural gas (LNG)-fired power plant with CO₂ capture that uses the energy of LNG for air separation. The estimated net efficiency of the plant is also about 40 percent.

Summary of the Invention

The invention features an improved combined cycle power plant that recycles CO₂ and emits virtually no pollutants, yet provides a good net thermal efficiency, i.e., electrical energy output versus thermal energy input. The plant is so effective in removing pollutants from the exhaust gases that it needs no smokestack. This plant can be fueled by natural gas (NG), liquid natural

- 3 -

gas (LNG), or synthesis gas, e.g., gasified coal. The outstanding benefit of the plant is in recovering essentially 100 percent of the CO₂ from the flue gas with a minimal loss of thermal efficiency. The captured CO₂ can be sequestered, e.g., in the deep ocean, or put to practical use, such as for enhanced oil recovery, or as a chemical feedstock.

The new power plant offers numerous significant advantages: (1) It is environmentally safe as the result of CO₂ capture and zero NO_x and SO_x emissions; (2) it operates at an overall thermal efficiency that is competitive to advanced conventional power plants that pollute the environment; and (3) it produces by-products in a suitable physical state for easy delivery and commercial use.

In general, the invention features a new power plant that includes an air separation unit arranged to separate oxygen from air and produce a stream of substantially pure liquid oxygen; a gas turbine arranged to combust a fuel, e.g., natural gas, liquefied natural gas, or synthesis gas, in the presence of substantially pure oxygen gas and carbon dioxide gas, and to produce an exhaust gas comprising water and carbon dioxide; and a carbon dioxide removal unit arranged to recover carbon dioxide gas from the exhaust gas, recycle a portion of the recovered carbon dioxide gas for passage through the gas turbine, and liquefy the remainder of the recovered carbon dioxide gas for removal from the plant. In this new plant, the carbon dioxide removal unit is thermally integrated with the air separation unit by directing the stream of liquid oxygen from the air separation unit to the carbon dioxide removal unit to liquefy the remainder of the recovered carbon dioxide gas, the liquid oxygen thereby evaporating and forming cold oxygen gas which is directed to cool the recycled carbon dioxide gas prior to

- 4 -

passage of the carbon dioxide gas through the gas turbine, and the oxygen gas is then directed to the gas turbine.

The air separation unit can also separate nitrogen
5 from the air and produce a stream of cold, substantially pure nitrogen. The cold nitrogen is directed to cool the air prior to separation of oxygen and nitrogen. The substantially pure nitrogen is at least 95 percent, and preferably at least 97 percent, nitrogen in the form of a
10 gas.

In the new plant, the "substantially pure" liquid (and gaseous) oxygen is at least 95 percent oxygen, and preferably at least 99.5 percent oxygen, or higher. This level of purity (at least 99.5%) is required to achieve
15 the cleanest operation and lowest levels of nitrogen oxides in the exhaust gas, e.g., less than 100 parts per million by volume of nitrogen oxides.

In one embodiment of the new power plant, about 95 percent of the carbon dioxide recovered from the exhaust
20 gas, which includes previously recycled carbon dioxide and carbon dioxide newly produced from combustion, is recycled for passage through the gas turbine, and about 5 percent of the recovered carbon dioxide is liquefied for removal from the plant. When the power plant is operated
25 at a steady state, an amount of carbon dioxide equal to 100 percent of the carbon dioxide produced from combustion is liquefied for removal from the plant.

The air separation unit can include a cooler arranged to cool the air prior to separation of oxygen, a
30 compressor arranged to pressurize the air prior to separation of oxygen, and a distillation tower arranged to separate the oxygen from the air.

The carbon dioxide removal unit can include a compressor arranged to pressurize the remainder of the
35 recovered carbon dioxide gas, a filter arranged to remove

- 5 -

water vapor from the remainder of the recovered carbon dioxide gas, a cooler arranged to cool the remainder of the recovered carbon dioxide gas, and a condenser arranged to liquefy the remainder of the recovered carbon dioxide gas using the liquid oxygen as a cooling source.

In another embodiment, the power plant further includes a compressor arranged to pressurize the liquid oxygen from the distillation column, e.g., to a high pressure such as 17 bar, prior to directing the liquid oxygen to the carbon dioxide removal unit to liquefy the remainder of the recovered carbon dioxide gas; and a heat exchanger arranged such that the cold oxygen gas from the air separation unit is used to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide gas through the gas turbine. Preferably, the power plant includes heat exchangers arranged such that both the cold oxygen gas and the cold nitrogen from the air separation unit are used to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide gas through the gas turbine.

The power plant can further include a heat recovery steam generator (HRSG) arranged to produce steam and a flue gas using the exhaust gas from the gas turbine as a heat source, and further arranged to heat the cold oxygen gas produced by liquefaction of the remainder of the recovered carbon dioxide gas, prior to passage of the oxygen into the gas turbine.

In another aspect, the invention features a new method of generating electricity with virtually zero pollutant emissions in a power plant having a gas turbine. The actual amount of pollutant emissions depends on the purity of the oxygen produced and the fuel used for combustion. Thus, "virtually zero pollutant emissions" as used herein means a level of pollutant emissions as close to zero as possible given the purity

- 6 -

of the fuel and oxygen entering the gas turbine, e.g., the exhaust gas contains less than 100 parts per million by volume of nitrogen oxides.

The new method includes the steps of arranging the
5 gas turbine to combust a fuel in the presence of substantially pure oxygen gas and carbon dioxide gas, and to produce an exhaust gas including water and carbon dioxide; recovering carbon dioxide gas from the exhaust gas; recycling a first portion of the recovered carbon
10 dioxide gas for passage through the gas turbine; separating oxygen from air and producing a stream of substantially pure liquid oxygen; directing the substantially pure liquid oxygen to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide
15 through the gas turbine, and to liquefy a remaining portion of the recovered carbon dioxide gas for removal from the plant, the liquid oxygen thereby evaporating and forming oxygen gas; and directing the oxygen gas to the gas turbine.

20 The method can include the further steps of separating nitrogen from the air and producing a stream of cold, substantially pure nitrogen; and directing the cold nitrogen to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide gas through the
25 gas turbine, and to cool the air, i.e., entering the air separation unit, prior to separation of oxygen and nitrogen.

In addition, the method can include the steps of compressing the substantially pure liquid oxygen prior to
30 evaporation of the liquid oxygen during liquefaction of the remaining portion of the recovered carbon dioxide gas, thereby forming cold oxygen gas; and heating the cold oxygen gas after directing the cold oxygen gas to cool the recycled carbon dioxide gas, and prior to
35 passage of the oxygen gas into the gas turbine.

- 7 -

In one embodiment of this method, about 95 percent of the recovered carbon dioxide gas is recycled, and about 5 percent of the recovered carbon dioxide gas is liquefied for removal from the plant. During steady
5 state operation, an amount of carbon dioxide equal to 100 percent of the carbon dioxide gas produced from combustion is liquefied for removal from the plant.

Unless otherwise defined, all technical and scientific terms used herein have the same meaning as
10 commonly understood by one of ordinary skill in the art to which this invention belongs. Although methods and materials similar or equivalent to those described herein can be used in the practice or testing of the present invention, the preferred methods and materials are
15 described below. All publications, patent applications, patents, and other references mentioned herein are incorporated by reference. In addition, the materials, methods, and examples are illustrative only and not intended to be limiting.

20 Other features and advantages of the invention will be apparent from the detailed description, and from the claims.

Brief Description of the Drawing

Fig. 1 is a block diagram of the overall
25 organization of a new recycling plant fired by natural gas.

Fig. 2 is a block diagram of the overall organization of a new recycling plant fired by gasified coal.

30 Fig. 3 is a block diagram of the integrated air separation and CO₂ capture (AS/CC) unit.

Fig. 4 is a schematic of an apparatus for carrying out the compression-evaporation method (CEM).

- 8 -

Fig. 5 is a detailed schematic of one embodiment of a new, natural gas-fired recycling plant.

Detailed Description

The improved plant combines several basic principles with new techniques. One principle used in the power plant is firing the fuel in pure or highly enriched oxygen instead of air. The combustion of a hydrocarbon in pure O_2 produces an exhaust or flue gas consisting of only H_2O and CO_2 with possible minor dissociation products, depending on the combustion temperature and pressure. Since H_2O is readily condensable (and reusable), the sole major combustion product is CO_2 ; the efficient capture thereof is the major purpose of the new plant design.

The invention introduces novel approaches and an integrated design to known state-of-the-art components. Two new aspects have been developed. The first is an integrated Air Separation and CO_2 Capture (AS/CC) unit. In the AS/CC unit, both processes of O_2 production and CO_2 removal ("capture") are carried out in a thermally integrated unit that significantly reduces the power consumption of CO_2 capture. The exergy ("free energy" available to do work) of liquid oxygen is used to capture CO_2 in the AS/CC unit. The integrated AS/CC unit adds between 4 to 6 percent to the overall efficiency of the new power plant.

The second aspect is the Compression-Evaporation Method (CEM) which is used to reduce the compression work of the gas turbine. In a conventional gas turbine, 50 to 60 percent of the total power produced by the gas turbine is consumed by the compressor of the gas turbine. There is little room to change this situation because the inlet fresh air must be compressed before entering the combustor of the gas turbine.

- 9 -

However, the CEM significantly improves the situation by utilizing liquid O_2 from the AS/CC unit to condense part of the recycled CO_2 . Liquid O_2 from a double column distillation tower of the AS/CC unit is first compressed to a high pressure, and then used to condense part of the CO_2 . The rest of the CO_2 is recycled back to the gas turbine. Evaporated O_2 is heated in a Heat Recovery Steam Generator (HRSG). The recycled CO_2 and the evaporated O_2 need less compression work, therefore this technique increases the efficiency of the gas turbine by adding about 3 percent or more to the overall power efficiency of the new plant.

The major components of the new plant include a double column distillation tower, CO_2 recycle compressor, gas turbine, HRSG, and steam turbine, which are all commercially available. Ordinary, commercially available gas turbines, such as Model V83, manufactured by the General Electric Corporation, can be used in this invention. However, since the working fluid of the new plant (mainly CO_2), differs in density, viscosity, specific heat, and heat transfer properties from the design working fluid (mainly N_2), the commercially available gas turbines may operate at a somewhat different efficiency.

In the following description, all of the gases were treated as ideal gases, including air, flue gas, O_2 , N_2 , and CO_2 . Steam tables from standard manuals were used to determine the thermodynamic properties of the H_2O , such as boiling temperature, enthalpy, and heat capacity.

Process Design Of The Power Plant

An overview of the power plant with CO_2 capture is given first, followed by a detailed description of the AS/CC unit and the CEM as used in a specific design for a natural gas-fired power plant. Modifications required

- 10 -

for use of the AS/CC and CEM in a gasified coal-fired plant are also described.

Fig. 1 shows the overall design of a natural gas-fired power plant according to the invention. As shown in Fig. 1, air is separated in the AS/CC unit into liquid O_2 , gaseous N_2 , and argon (Ar). The gaseous N_2 can be either vented into the atmosphere or sold as a by-product. The argon is produced as a by-product. The liquid O_2 is compressed, e.g., to 17 bar, then sent to the CO_2 liquefier to be evaporated while condensing the gaseous CO_2 . The evaporated O_2 is then sent to the combustor of the gas turbine. The combustion products are essentially CO_2 and H_2O , which are used to generate power in the gas turbine.

The gas turbine exhaust (H_2O/CO_2) is used to generate steam in the HRSG for power generation in the steam turbine. Part of the steam may be used as process steam (cogeneration). After leaving the HRSG, the flue gas is cooled to room temperature. Water vapor is then removed from the flue gas, leaving pure CO_2 in the stream. The CO_2 splits into two streams. One is recycled, while the other is removed from the system as a saleable by-product.

The plant has a net efficiency of 45%, compared to the gross efficiency (without CO_2 capture) of 54%. This is a modest efficiency loss when weighed against the environmental benefits of this plant, and the possibility of deriving revenue from the sale of pure liquid CO_2 and pure gaseous nitrogen and argon. The net efficiency of the plant can reach 47% when LNG is used instead of NG. The plant can also be run in a cogeneration mode, in which process or district heating steam can be sold as a by-product.

As shown in Fig. 2, the overall design of the gasified coal-fired power plant according to the

- 11 -

invention is quite similar to the design described above, but allows the use of coal, rather than natural gas, as the fuel. A standard commercial coal gasification process can be used as described in, e.g., Schütz et al.,
5 Energy Conversion and Management, 33:357-363 (1992); Hendriks and Blok, Energy Conversion and Management, 33:387-396 (1992); and J. Douglas, Electric Power Research Institute Journal, pp. 2-11, September 1986.

Both the steam and oxygen supply needed for coal
10 gasification comes from the new power plant with CO₂ capture. A portion of the steam generated in the Heat Recovery Steam Generator (HRSG) serves as the steam input of the coal gasifier. Also, a portion of the oxygen generated in the AS/CC is directed to the oxygen input of
15 the coal gasifier.

Specifically, ambient air is separated in the AS/CC unit into liquid O₂, gaseous N₂, and Ar, as in the NG-fired plant, and both the N₂ and Ar can be either vented into the atmosphere or sold as a by-product.
20 However, in the coal-fired plant, the produced O₂ splits into two streams. One stream is diverted to the coal gasifier, where coal, O₂, and steam are converted into synthesis gas ("syngas" or SG), which in its simplest form consists of carbon monoxide and hydrogen. The other
25 O₂ stream is sent to the combustor of the gas turbine. The combustion products are CO₂ and H₂O.

As in the natural gas-fired plant, the gas turbine exhaust is used to generate steam in the HRSG for power generation in the steam turbine. After leaving the HRSG,
30 the flue gas is cooled to room temperature. Water vapor is removed from the flue gas, and the remaining flue gas is substantially pure CO₂, which is split into two streams. One stream is recycled, and the other is removed from the system, e.g., as liquid CO₂.

- 12 -

Combustion of NG or SG in a mixture of CO_2/O_2 involves the intimate mixing of NG or SG with O_2 molecules in a moving stream. Oxygen must be introduced around the NG or SG nozzle in the combustor. Recycled CO_2 is introduced gradually downstream of the nozzle. The flame length should be sufficient to allow NG or SG enough time and space for complete combustion.

The net thermal efficiency of the SG or gasified coal-fired plant, i.e., the electric energy generated versus the thermal energy of coal input, including the energy required for oxygen production, coal gasification, and CO_2 compression and recycling, is 36.6 percent. This is about 8 percent lower than the natural gas-fired plant, which does not require energy for coal gasification.

Air Separation And CO_2 Removal (AS/CC) Unit

Air separation can be accomplished using commercially available devices that use known processes such as cryogenic separation, pressure-swing adsorption, membrane separation, or Brin's process. The cryogenic process is preferred for use in the AS/CC unit.

Fig. 3 shows the overall conceptual design of the AS/CC. The air separation part of the AS/CC unit separates the ambient air into pure O_2 , N_2 , and Ar. The cold energy of O_2 and N_2 is used to cool the flue gas coming from the gas turbine. The H_2O of the flue gas is condensed and removed in the CO_2 capture part of the AS/CC unit. The majority of the CO_2 gas from the exhaust gas, which includes previously recycled CO_2 and CO_2 newly produced from combustion, typically 95 percent or more, is recycled. The remainder of the CO_2 gas separated from the exhaust or flue gas is liquefied and stored in a CO_2 tank, e.g., for sale as a by-product. Solid CO_2 can also be produced as a by-product with simple modifications of the system.

- 13 -

Theoretically, the liquid O_2 contains enough cold energy to liquefy the recycled CO_2 . However, in practice the cold energy of O_2 is not totally sufficient for the process. Thus, some energy, e.g., electricity, is
5 required to compress the CO_2 to a pressure sufficient for liquefaction, e.g., greater than 5.1 bar. Still, this process will save significant amounts of power necessary to liquefy gaseous CO_2 .

In the AS/CC unit, O_2 production and CO_2 capture
10 are carried out in a thermally integrated unit. The total energy consumption of the AS/CC unit in the plant described below for CO_2 removal is as low as 400 kWh per tonne of CO_2 removed, compared with 550 to 800 kWh of energy required to remove each tonne of CO_2 from ordinary
15 flue gas using known methods. These numbers are based on the assumptions that the plant generates 210 MW of electricity and 51 tonnes of process steam per hour, and 9878 tonnes of nitrogen, 162 tonnes of argon, and 2102 tonnes of liquid carbon dioxide per day.

20 These numbers compare well with numbers for known air separation units, which require about 280 to 400 kWh of electricity to produce one tonne of O_2 , and typical CO_2 removal units, which require about 160 to 250 kWh of electricity to capture one tonne of CO_2 . Together, these
25 units require a total of 550 to 800 kWh to remove one tonne of CO_2 and produce one tonne of O_2 .

Compression-Evaporation Method (CEM) And Energy Recovery

Fig. 4 is a detailed schematic diagram of the CEM. An AS/CC unit separates ambient air (state 1) into liquid
30 O_2 , N_2 , and Ar. The cold exergy of liquid O_2 is used to liquefy CO_2 , thereby evaporating the O_2 . The liquid CO_2 (stream 55) is stored in a CO_2 tank 55'. The cold, high pressure O_2 gas (stream 14) leaving the AS/CC is used to cool the recycled CO_2 (stream 24b) in heat exchanger HX5.

- 14 -

The cold N_2 (stream 52) from the AS/CC unit is used to cool stream 24a (recycled CO_2) in heat exchanger HX4.

Two streams (25a and 25b) of the cooled recycled CO_2 are recombined to produce stream 26, a portion of which (stream 27) enters the compressor 27' of the gas turbine 20'. Lowering the inlet temperature of the compressor increases the gas density and power capacity of the gas turbine. A decrease of one degree Kelvin (K) in the inlet temperature raises the power capacity of the gas turbine by about 1%.

The gaseous O_2 (stream 15) is further heated in the HRSG to a high temperature (stream 16). This design raises the average inlet temperature of the working fluid of the gas turbine, which in turn, reduces fuel consumption. The fuel consumption of a gas turbine depends on combustion efficiency, the average inlet temperature of the working fluid, and the final average temperature of the combustion products.

O_2 can be supplied to the combustor 20 of the gas turbine in two ways. In a first option, the O_2 (stream 16) is mixed with a portion of the recycled CO_2 (stream 18b) in a mixer 19' to produce a stream 19 which enters the combustor of the gas turbine. This ensures a good mixing result. Alternatively, in a second option, O_2 (stream 16) is sent directly to the combustor 20. The effluent gas (stream 20a) of the combustor consists of H_2O and CO_2 , and is used to power the gas turbine 20'. The thermal energy of the exhaust gas (stream 21) of the gas turbine is utilized to generate high pressure steam (stream 44) in the HRSG.

The flue gas (stream 22) leaving the HRSG is cooled to room temperature (stream 23) by ambient water in a water cooler 22' where water vapor of the flue gas is condensed and removed. The rest of the flue gas is pure CO_2 (stream 23). The CO_2 splits into two streams 27

- 15 -

and 28. Stream 27, about 95% of the total, is recycled to the compressor 27' of the gas turbine 10'. CO₂ stream 28 is sent to the AS/CC unit to be liquefied as a by-product.

5 A Natural Gas-Fired Power Plant

The following power plant is designed to generate 210 MW of electricity and 51 tonnes of process steam (10 bar and 453°K) per hour. The plant will also produce saleable by-products including 9878 tonnes of N₂, 162
10 tonnes of Ar, and 2102 tonnes of liquid CO₂ per day. The plant will generate both electricity and process steam with no environmental impact while yielding high power efficiency and good economic profit.

Integrated Air Separation and CO₂ Removal

15 Fig. 5 is a detailed schematic diagram of a natural gas-fired power plant. The starting point of the process is the production of pure O₂ which is separated from the ambient air. The ambient air (stream 1) is first passed through a dust filter 1'. The clean air
20 (stream 2) is compressed to a high pressure (stream 3), e.g., 18 bar, by a three-stage compressor 2'. The air is cooled by ambient water in coolers 2a and 2b between each stage. CO₂ in the compressed air is removed in a CO₂ scrubbing tower 2c using a caustic soda solution which is
25 a conventional apparatus, e.g., as described in Austin, Shreve's Chemical Process Industries (McGraw-Hill, New York, 1984).

The discharged air (stream 3) is cooled again by ambient water in cooler 3' to state 4. An alumina drier
30 4' removes water vapor in the compressed air. The air stream 5 splits into two streams. Stream 6a is cooled by cold gaseous N₂ in a first heat exchanger HX1. Stream 6b is cooled by the cold gaseous O₂ in a second heat exchanger HX2. The two streams are recombined to produce
35 stream 8. Stream 8 is cooled by cold N₂ (stream 50)

- 16 -

alone in a third heat exchanger HX3. The compressed and cold air (stream 9) is further cooled by expansion through a recovery turbine 9', which recovers some energy of the compressed air. The exhausted temperature and
5 pressure of the air (stream 10) is 104°K and 5 bar respectively.

Air stream 10 is then sent to the double column distillation tower 10', which consists of two tray-type distillation columns thermally connected at the center
10 through a heat exchanger. The heat exchanger serves as a condenser for the lower column and a boiler for the upper column. Because N_2 is more volatile than O_2 , N_2 will ascend and O_2 will descend in each column. On the boiler side of the upper column, there is a pool of high purity
15 liquid O_2 , while on the condenser side of the lower column, N_2 is condensed. Because the normal boiling temperature of O_2 is 12.8°K higher than that of N_2 , the pressure in the lower column must be high enough to raise the condensing temperature of N_2 sufficiently to provide
20 a positive temperature driving force in the main condenser. Thus, the pressure of the lower column should be between 5 and 6 bar. The corresponding temperature of the column should be kept at about 103 to 104°K.

The condensed N_2 is split. One portion of N_2
25 returns to the lower column as reflux, and the other portion is sent to the upper column also as reflux. An O_2 rich liquid stream leaves the bottom of the lower column and serves as the main feed stream for the upper column. The pure O_2 product removed as a saturated
30 liquid (stream 11) from the main condenser has a purity of at least 99.7%. High purity N_2 (stream 50), with 2% to 3% O_2 , is removed as saturated vapor from the top of the upper column.

The separated liquid O_2 (stream 11) at 1.5 bar
35 from the upper column is compressed in a pump 11' to 17

- 17 -

bar (stream 12), then sent to a CO₂ condenser 12' to liquefy the pure CO₂ gas (stream 32). This process saves most of the power used in liquefying the gaseous CO₂ separated from the flue gas. Compression of liquid O₂ requires much less work than compression of gaseous O₂. Thus, this process saves significant amounts of power in capturing CO₂ compared to other designs where the separation and CO₂ removal units are not thermally integrated.

10 Flue gas containing CO₂ and H₂O (stream 22) from the heat recovery steam generator (HRSG) is cooled by ambient water in cooler 22' where water vapor in the flue gas is condensed and removed from the CO₂. Cooled CO₂ stream 23 splits into two streams 24a and 24b which are
15 proportional to the mole flow rate of N₂ and O₂, respectively. Such a design ensures that the two streams will have the same final temperature. Stream 24a is cooled by cold N₂ (stream 52) from the distillation column in a fourth heat exchanger HX4. Stream 24b is
20 cooled by cold O₂ (stream 14) from the CO₂ condenser in a fifth heat exchanger HX5. The temperature of the O₂ (stream 2) depends on the operating conditions, which are usually in the range of 270-280°K.

Two streams of CO₂, now cooled, are recombined to
25 produce stream 26, which then splits into streams 27 and 28. Stream 27 is recycled back to the compressor 27' of the gas turbine 20'. Stream 28 is compressed to state 29 in a two-stage compressor 28' with inter-stage cooling (cooler 28a). Drier 29' uses silica gel or a molecular
30 filter to remove the rest of the water vapor in the CO₂ to avoiding icing during liquefaction of the CO₂. The compressed, dry CO₂ gas (stream 30) is cooled again by ambient water in cooler 30a to produce stream 31. Stream 31 is further cooled by expansion through an expansion
35 valve 31'. In the CO₂ condenser 12', gaseous CO₂ is

- 18 -

liquefied by evaporation of the liquid O_2 (stream 12) produced in the double column tower 10'. The condensed liquid CO_2 (stream 55) is stored in a CO_2 tank 55'.

Gas Turbine

5 A model V83 gas turbine, manufactured by General Electric, or the like, e.g., having a mass flow rate of the flue gas of about 420 kg/sec when burning NG in air, can be used in the new power plant. When burning NG in a mixture of O_2 and CO_2 , the mass flow rate of the flue gas
10 would be about 621 kg/sec.

As shown in Fig. 5, cold N_2 (stream 52) and O_2 (stream 14) from the air separation process are used to cool the recycled CO_2 (stream 27) before the CO_2 enters the turbine compressor. Therefore the temperature of the
15 recycled CO_2 (stream 27) can be kept at a desired value regardless of the variation of the surrounding temperature. This will eliminate the power capacity variations found in conventional air combustion gas turbines where air temperature changes lead to air
20 density changes, which in turn impact the mass flow of the air through the gas turbine and consequently the power capacity.

The gaseous O_2 (stream 15) from heat exchanger HX5 is heated by an O_2 heat exchanger (O2HX) in the HRSG.
25 The heated O_2 (stream 16) is mixed with CO_2 stream 18b in mixer 16'. The mixed stream 19 is then sent to the combustor 19'. CO_2 stream 18a is used as diluting fluid.

Combustor

The combustion of natural gas (NG) occurs mostly
30 in the recirculation and combustion zones, and involves the intimate mixing of molecules of NG with O_2 molecules. Since O_2 is a small portion of the working fluid, the mixture of O_2 and CO_2 should be introduced around the NG nozzle in the combustor to provide a high temperature and
35 a good mixing with NG for rapid combustion. The flame

- 19 -

length must be suitable to allow enough time and space for the NG to be completely burned.

Since NG is burned in an O₂ enriched atmosphere in this plant design, the flame temperature is much higher than if NG were burned in air. A significant percentage of the CO₂ in the combustion products is in a dissociation state (CO). If the hot gas were to pass directly to the dilution zone and be rapidly cooled by addition of massive amounts of CO₂, the CO would "freeze" and be discharged unburned. Therefore, the diluting CO₂ should be gradually introduced along the combustor. The combustor should be large enough to allow the CO enough space and time to release heat and revert to CO₂.

Steam Turbine and HRSG

The steam turbine can have a rated power capacity of, e.g., 75 MW. Commercially available HRSGs are designed to recover a high percentage, e.g., at least 92 percent, of the thermal energy in the exhaust gas from the gas turbine.

The thermal energy of the CO₂/H₂O exhaust (stream 21) of the gas turbine 20' is utilized to generate steam in the HRSG. The HRSG produces steam at two different pressures to utilize the thermal energy of the exhaust gas efficiently. High pressure steam (stream 44) is generated in a high pressure drum 42' and superheater 43', and is used mainly to generate electricity.

When the plant is operated as a cogeneration plant, process steam (stream 49) consists of two streams 39 and 48. Low pressure steam (stream 39) is generated in a low pressure drum 38'. Stream 48 is extracted from the middle stages of the steam turbine 44'. When more process steam is required, steam can be extracted from the steam turbine. However, the extraction of steam will reduce the power output of the steam turbine.

- 20 -

The make-up water (stream 33) of the HRSG is at ambient temperature (300°K) and is pumped to a higher pressure by pump 33'. Stream 34 is heated (stream 35) in an economizer 34', and then sent to a deaerator 35' to
5 remove excess air. Ninety percent of the process steam (stream 54) is returned to the plant.

The average temperature of the mixed water (state 36) in the deaerator is about 350°K. This water is pumped by pump 36' to heat exchanger HX7 to be heated to
10 about 453°K. In the low pressure steam generator, a fraction of the water (stream 39) is evaporated and sent out as process steam at 453°K and 10 bar. The rest of the water (stream 40) is pumped to a high pressure steam (stream 41) by pump 40', then further heated (stream 42)
15 in a sixth heat exchanger HX6. Stream 42 is sent to a high pressure generator 42'. The saturated steam (stream 43) is further heated in a superheater 43'. The superheated steam (stream 44) expands through a steam turbine 44' to generate electricity. A fraction (stream
20 48) of the steam is extracted at 10 bar and delivered as process steam (stream 49). The rest of the steam is further expanded in the turbine. The exhaust steam (stream 45) is condensed in a condenser 45' to state 46, is pumped to a high pressure (8 bar) by pump 46', and
25 directed to the deaerator 35'.

Steady State Model of the Power Plant

A steady state model of the power plant depicted in Fig. 5 was used to determine the temperatures and pressures at key points in the plant. In this model, it
30 was assumed that the ambient temperature is 300°K, the minimum temperature difference between the hot stream and the cooled stream in all of the coolers is 10°K, the net electric output of the plant is 210 MW, and the process steam output is 51 tonnes per hour. The thermal states
35 of the working fluids in the process are calculated using

- 21 -

the first and second laws of thermodynamics. The equations used to determine the values in Table 1 below can be derived from the principles of thermodynamics, and are found in the Ph.D. Thesis of Dr. Yulin Shao, entitled
5 "Conceptual Design and Analysis of a Natural Gas Fired Power Plant with Carbon Dioxide Capture." This thesis is available at the O'Leary Library at the University of Massachusetts, Lowell, Massachusetts (catalog number 1994 PH-4). The thesis is also available on microfilm at the
10 Lydon Library of the University of Massachusetts, Lowell, Massachusetts.

These equations, like the numbers in Table 1 below, are representative of one model of a power plant according to the invention, and are not required to
15 manufacture such a plant.

The following additional assumptions were made to generate the data in Table 1: the efficiency of the air compressor is 90%, the efficiency of the recovery turbine is 90%, condensing pressure of CO₂ is 7.34 bar,
20 condensing pressure of the steam turbine is 0.2 bar, and the temperature of the returned process steam is 443°K.

- 22 -

Table 1 - Steady State of the Power Plant

	Point	Mass	T (K)	P (bar)
	1	air	300	1
	2	air	300	1
5	3	air	406	18
	4	air	310	18
	5	air	310	18
	6a	air	310	18
	6b	air	310	18
10	7a	air	240	18
	7b	air	240	18
	8	air	240	18
	9	air	145	18
	10	air	104	5
15	11	O ₂	90	1.5
	12	O ₂	≈110	17
	13	O ₂	210	17
	14	O ₂	280	17
	15	O ₂	300	17
20	16	O ₂	433	17
	17	CO ₂	605	17
	18a	CO ₂	535	17
	18b	CO ₂	535	17
	19	O ₂ /CO ₂	490	17

- 23 -

	Point	Mass	T (K)	P (bar)
	20	O2/CO2	529	17
	20a	CO2/H2O	1140	17
	21	CO2/H2O	810	1.1
5	22	CO2/H2O	393	1.1
	23	CO2	310	1.1
	24a	CO2	310	1.1
	24b	CO2	310	1.1
	25a	CO2	300	1.1
10	25b	CO2	300	1.1
	26	CO2	300	1.1
	27	CO2	300	1.1
	28	CO2	300	1.1
	29	CO2	383	8
15	30	CO2	383	8
	31	CO2	310	8
	32	CO2	304	7.43
	33	H2O	300	5
	34	H2O	300	8
20	35	H2O	353	8
	36	H2O	349	8
	37	H2O	349	10
	38	H2O	453	10

- 24 -

	Point	Mass	T (K)	P (bar)
	39	H2O (steam)	453	10
	40	H2O	453	10
	41	H2O	453	58
5	42	H2O	555	58
	43	H2O (steam)	555	58
	44	H2O (steam)	755	58
	45	H2O (steam)	333	0.2
	46	H2O	333	0.2
10	47	H2O	333	8
	48	H2O (steam)	453	10
	49	H2O (steam)	453	10
	50	N2	91	1.5
	51	N2	210	1.5
15	52	N2	280	1.5
	53	N2	300	1.5
	54	H2O	433	8
	55	CO2 (liquid)	225	7.43
	56	NG	300	1.5
20	57	NG	438	17

Material and Energy Balance

The design of the gas turbine and the HRSG and steam turbine governs the material and energy flows of the system. The material and energy balance of the natural gas-fired power plant include (1) the gas turbine, (2) the steam turbine and HRSG, and (3) the integrated AC/CC unit. The detailed calculation is based on the following assumptions: (a) the inlet temperature of the gas turbine is 1140°K; (b) the exhaust temperature of the gas turbine is 810°K; (c) the pressure ratio of the gas turbine is 15.6; (d) the mole flow rate of the gas turbine is 14,737 mole/s, which leads to a mass flow of the exhaust (flue) gas of 420 kg/s when burning NG in

- 25 -

air, and 621 kg/s in a mixture of O_2/CO_2 ; (e) the compressor adiabatic efficiency is 85%; (f) NG consists of 82% CH_4 and 18% C_2H_6 ; (g) the rated power capacity of the steam turbine is 75 MW; (h) the inlet temperature and
 5 pressure of the steam turbine are 755°K and 58 bar, respectively; (i) the condensing pressure of the steam is 0.2 bar; and (j) moisture of the exhaust steam is 14%.

Table 2 below lists the material balance of the components of the NG-fired plant. Table 3 lists the
 10 energy balance.

Table 2 - Material Balance of an NG-Fired Plant

	Mass	In	Out
		(kg/s)	(kg/s)
GT	NG	8.7	
	O_2	35	
	CO_2	577.7	
	Flue Gas		621.4
HRSG&ST	Flue Gas	621.4	621.4
	H_2O	80	80
AS/CC	Air	151.3	
	O_2		35
	N_2		114.3
	AR		2
	Flue Gas	621.4	
	CO_2		25.3
	CO_{2r}		577.7
	H_2O		18.4

- 26 -

Table 3 - Energy Balance of an NG-Fired Plant

		In	Out
		(MW)	(MW)
GT	Energy*	477	281
	Electricity		168.9
HRSG&ST	Energy	281	
	Electricity		83.3
AS/CC	Electricity	42.2	
	Cold exergy		20

5 *includes 464 MW chemical energy and 13 MW thermal energy

Efficiency Analysis

To produce electric power, the gas turbine consumes a certain amount of O₂ per day. CO₂ production is proportional to O₂ consumption. The net power output
 10 of the plant is the difference the total electric power produced by the plant and the power consumed by the processes of O₂ production and CO₂ removal. The power efficiency of the plant is defined as the ratio of the total electricity output to the total energy input. When
 15 auxiliary power consumption is consider such as lighting and pumping, the power efficiency of the new plant is

$$\eta_{\text{net}} = (P_{\text{GT}} + P_{\text{ST}} - P_{\text{i}}) (1 - e) (E_{\text{in}})^{-1} \quad (1)$$

where η_{net} is net efficiency of the plant, P_{GT} is the power output of gas turbine, P_{ST} is the power of the steam
 20 turbine, P_{i} is the internal power consumption, e is a factor representing auxiliary power consumption, and E_{in} is the energy input of the new plant.

Assuming e is 0.5%, the net power efficiency of the NG-fired plant (η_{net}) is 45 percent. The gross power
 25 efficiency, defined as the total power generated to the total energy input (η_{gross}), is 54 percent. When LNG is

- 27 -

used instead of NG, η_{net} is 47 percent. Thus, 16.6% is lost due to CO₂ recapture.

A Gasified Coal-Fired Power Plant

Fig. 2 illustrates a block diagram of a power
5 plant fired by gasified coal or syngas (SG). The innovation of the gasified coal-fired plant is the integration of state-of-the-art technologies, and the introduction of the AS/CC and CEM described above, which work equally well in a gasified coal-fired plant. These
10 new techniques and methods are modified for use in the gasified coal-fired plant.

For example, fifty to sixty percent of the total power generated by the turbine is consumed by the compressor. There is little room to change this
15 situation in conventional gas turbines, because inlet fresh air must be compressed before entering the combustion. The new gasified coal-fired plant reduces the energy consumed by the compressor by use of the CEM. Liquid O₂ produced from the double column distillation
20 tower in the AS/CC is first compressed to a high pressure. The O₂ is then evaporated and heated in exchangers by condensing captured CO₂ and cooling inlet fresh air used for air separation. Finally, the O₂ is sent to the combustor. Since compression of a liquid
25 requires much less energy than compression of a gas, this design will save a portion of the power used by the compressor. About 10 percent of the "combustion air" of the gas turbine bypasses the compressor section. The reduction of mass flow saves up to about 3 percent of the
30 compression energy of the gas turbine.

Simulation of the flame characteristics in the combustor, in both the NG-fired and SG-fired plant, can be performed using Sandia CHEMKIN computer software described in Kee et al., The CHEMKIN Computer Code,
35 SAND80-8003 (1980). An analysis of the optimum ratio of

- 28 -

CO₂/O₂ also can be performed using this software. The optimum mass ratio is estimated to be 12:1. An excess of 3 percent oxygen over the stoichiometric amount is deemed necessary for complete combustion.

5 On the basis of the results of such a simulation, heat transfer theory, and energy balance, the quantity of the recycled flue gas and the average temperature of the combustion products (stream 20a) is estimated to be 1140°K. The temperature of the combustion products
10 should be in the range tolerable to the turbine materials. Under well-designed film cooling, most turbine materials can withstand temperatures up to 1400-1500°K.

 It is also noted that this plant, fired either by
15 pure NG or SG, produces no nitrogen oxides (NO_x). Since NG or SG are combusted in almost pure oxygen (99.5+% pure), there is no opportunity to form NO_x in the combustor. CHEMKIN computer code calculations confirm that the concentration of NO_x will be only in the tens of
20 parts per million by volume (ppmV) in the flue gas when NG or SG are combusted in 99.5 percent oxygen and 0.5 percent nitrogen. Preferably this number is less than 100 ppmV of NO_x.

 Syngas can be combusted in O₂/CO₂ in three modes:
25 (1) with the gases premixed; (2) with SG and O₂ premixed, and CO₂ added downstream; and (3) using a concentric annulus burner in which an inner annulus supplies SG, a middle annulus provides O₂, and an outer annulus supplies CO₂.

30 Material and Energy Balance of an SG-Fired Plant

 Coal gasifier: Coal is gasified in the coal gasifier, along with O₂ and water. The Low Heating Value (LHV) of the coal used in the gasified coal-fired plant is assumed to be 25 MJ/kg. In commercial coal gasifiers,
35 the mass ratio of coal to H₂O is about 1.3-2.5, and the

- 29 -

mass ratio of O_2 to coal is in the range of 0.35 to 1. Syngas can consist of, e.g., 40-60% CO , 10-30% CO_2 , 20-30% H_2 , and 1-2% other gases. The mass flow of SG can be determined according to the mass balance of the coal
5 gasifier.

$$M_{SG} = M_{c1} + M_{O2} + M_W - M_{s1} \quad (2)$$

where M_{SG} is the mass flow of SG, M_{c1} is the mass flow of coal, M_{O2} is the mass flow of O_2 , M_W is the mass flow of water, and M_{s1} is the mass flow of slag.

10 The energy input of the gasifier consists of the energy of coal, water, and O_2 . The energy output of the gasifier consists mainly of the combustion heat of SG.

Gas turbine: In the SG-fired plant, the working fluid of the gas turbine is mainly CO_2 . Similar to the
15 NG-fired plant, the mass flow rate of the exhaust of the gas turbine is given by the turbine manufacturer. The rest of the mass flow rates of the gas turbine including SG, O_2 , and recycled CO_2 can be determined. When the energy efficiency of the gas turbine is the same as that
20 in the NG-fired plant, the power output of the gas turbine is $P_{GT} = \eta_{GT} E_{SG}$. Here, P_{GT} is the power output of the gas turbine, η_{GT} is the energy efficiency of the gas turbine, and E_{SG} is combustion heat of SG.

HRSG and Steam Turbine: The mass flow rate of the
25 flue gas in the HRSG is constant, and equals the exhaust of the gas turbine. The maximum amount of steam produced in the HRSG is restricted by energy conservation and useful available energy above the saturated temperature of the steam. The thermal energy of the flue gas of the
30 gas turbine is used to generate steam which goes to the steam turbine. Process steam is extracted at the middle stage of the steam turbine. Extraction of steam will reduce the power output of the steam turbine. Similarly

- 30 -

to the NG-fired plant, the power generated by the steam turbine is $P_{ST} = M_{TS}/M_{ms}$. Here, M_{TS} is the total steam flow through the steam turbine, and M_{ms} is the steam flow rate required to generate 1 kWh of electricity.

- 5 AS/CC: The air separation process generates O_2 for SG combustion and coal gasification. O_2 is separated from ambient air. Therefore, the production of N_2 and Ar is proportional to the O_2 consumption of the system. The CO_2 removal process must condense and remove the CO_2
- 10 produced in SG combustion as well as in coal gasification. Energy consumption of the AS/CC consists of O_2 production and CO_2 removal.

Tables 4 and 5 summarize the material balance and energy balance of the SG-fired plant, respectively.

- 15 Here, CO_{2r} is the CO_2 recycled back to the gas turbine. Energy includes thermal energy and chemical energy except energy output of the gasifier, which is the combustion heat of SG. Electricity consumption of the AS/CC includes O_2 generation and CO_2 compression.

- 31 -

Table 4 - Material Balance of an SG-Fired Plant

	Mass	In (kg/s)	Out (kg/s)
Gasifier	Coal	17.8	
	O ₂	14.2	
	H ₂ O	23.1	
	SG		49.4
	Slag		5.7
Gas Turbine (GT)	SG	49.4	
	O ₂	29	
	CO ₂	572.3	
	Flue Gas (FG)		650.7
5 HRSG & Steam Turbine (ST)	FG	650.7	650.7
	H ₂ O	81	81
AS/CC	Air	192.3	
	O ₂		44.5
	N ₂		145.4
	Ar		2.4
	FG	650.7	
	CO ₂		66.2
	CO _{2r}		572.3
	H ₂ O		12.2

Table 5 - Energy balance of an SG-Fired Plant

		In (MW)	Out (MW)
10 Gasifier	Energy*	455.3	444.6
	GT		
GT	Energy	444.6	276
	Electricity		162.4
HRSG & ST	Energy	276	10.3
	Electricity		71.5
AS/CC	Electricity**	70.4	
	Cold exergy		33.1

*includes 444.6 MW chemical and 10.7 MW thermal energy

15 **includes 21.4 MW for O₂ production for the gasifierEnergy Efficiency of the SG-Fired Plant

More O₂ is consumed in the SG-fired plant than in the NG-fired plant, and more CO₂ is removed from the SG-

- 32 -

fired plant in terms of kg O₂ and kWh of electricity. Therefore, the net power efficiency of the SG-fired plant is lower than that of the NG-fired plant. When auxiliary power consumption is considered, the net power efficiency
5 of the SG-fired plant is

$$\eta_{\text{net2}} = (P_{\text{GT}} + P_{\text{ST}} - P_{\text{i}}) (1 - e) (E_{\text{in}})^{-1} \quad (3)$$

When e is 0.5%, the net power efficiency of the SG-fired plant (η_{net2}) is 36.6%. The gross power efficiency of the SG-fired plant (η_{gross}) is 47.8%. The gross energy
10 efficiency is defined as the ratio of the total power generated minus 21.4 MW for coal gasification to the total energy input (coal energy) without CO₂ capture. Thus, 23.4% is lost due to CO₂ recapture and coal gasification.

15 Operation

The new power plant is operated in a manner similar to existing power plants, but does not require any pollution control devices, or even a smokestack, since the only emissions are nitrogen and argon gas,
20 which both can be retained and sold as by-products, and water or water vapor. The plant is supplied with fuel, e.g., natural gas, liquefied natural gas, or synthesis gas, e.g., from coal gasification in the same way the existing plants are supplied. The electric and steam
25 power generated by the plant are delivered and used in the customary way. There is, however, a transition period not found in existing plants.

Transition State Operation

The use of a working fluid that is mostly CO₂ with
30 some H₂O in the new power plant requires a large amount of CO₂ in the transition period between the start of operation of a new plant and a steady state operation. The total amount of the working fluid (CO₂) required by

- 33 -

the plant described above can reach 10,000 tonnes during the transition period. The transition period is defined as the total time required to generate enough CO₂ for the recycling ratio (CO₂:O₂) to reach 12:1. This initial
5 amount of CO₂ can be supplied in two ways.

First, the CO₂ can be purchased from an external supplier and filled into the plant. The plant will no longer require CO₂ input after the transition period. Second, the CO₂ can be gradually generated by the plant
10 itself by operating in a transition state. Under design conditions, the plant will generate about 2102 tonnes of CO₂ per day. Therefore, it will take the plant about five days to generate 10,000 tonnes of CO₂. In the transition state, the plant has zero CO₂ output. All of
15 the CO₂ recovered from the exhaust gas during the transition state is recycled through the gas turbine, i.e., none is liquefied for removal from the plant.

Steady State Operation

When a sufficient amount of CO₂ for the working
20 fluid has accumulated, the plant will continuously recycle about 95 percent of the total CO₂ recovered from the exhaust gas. This total amount of CO₂ includes previously recycled CO₂ and CO₂ newly produced by combustion. In this steady state operation, about 5
25 percent of the total CO₂ recovered is liquefied and removed from the plant. This constitutes an amount of CO₂ equal to 100 percent of the CO₂ newly produced by combustion in the plant.

Once operating under steady state conditions, the
30 plant described above will generate 210 MW of electricity and 51 tonnes of process stream per hour, and will also produce saleable by-products, including 9878 tonnes of nitrogen, 162 tonnes of argon and 2102 tonnes of liquid carbon dioxide per day. Considering the fact that the
35 plant produces these valuable by-products, it is highly

- 34 -

profitable besides being environmentally "clean." The novel concepts and techniques described above, namely the integrated AS/CC unit and the CEM, push the net power efficiency of the NG-fired plant to 45% and that of the
5 gasified coal-fired or SG-fired plant to 36.6%. The net efficiency reaches 47% when LNG is used instead of NG.

The efficiency losses due to CO₂ recovery are relatively modest when one considers the environmental gains of nearly 100% CO₂ recovery, no sulfur oxides, no
10 nitrogen oxides, and no particulate emissions. Furthermore, the new plants produce saleable by-products, which makes them economically competitive with advanced conventional power plants.

Other Embodiments

15 It is to be understood that while the invention has been described in conjunction with the detailed description thereof, that the foregoing description is intended to illustrate and not limit the scope of the invention, which is defined by the scope of the appended
20 claims. Other aspects, advantages, and modifications are within the scope of the following claims.

What is claimed is:

- 35 -

Claims

1. A power plant comprising
an air separation unit arranged to separate oxygen
from air and produce a stream of substantially pure
5 liquid oxygen;
a gas turbine arranged to combust a fuel in the
presence of substantially pure oxygen gas and carbon
dioxide gas, and to produce an exhaust gas comprising
water and carbon dioxide; and
10 a carbon dioxide removal unit arranged to recover
carbon dioxide gas from the exhaust gas, recycle a
portion of the recovered carbon dioxide gas for passage
through said gas turbine, and liquefy the remainder of
the recovered carbon dioxide gas for removal from the
15 plant;
wherein said carbon dioxide removal unit is
thermally integrated with said air separation unit by
directing the stream of liquid oxygen from said air
separation unit to said carbon dioxide removal unit to
20 liquefy the remainder of the recovered carbon dioxide
gas, the liquid oxygen thereby evaporating and forming
cold oxygen gas which is directed to cool the recycled
carbon dioxide gas prior to passage of the carbon dioxide
gas through said gas turbine, and the oxygen gas is then
25 directed to said gas turbine.
2. A power plant of claim 1, wherein the fuel is
natural gas, liquefied natural gas, or synthesis gas.
3. A power plant of claim 1, wherein said air
separation unit separates nitrogen from the air and
30 produces a stream of cold, substantially pure nitrogen,
and wherein the cold nitrogen is directed to cool the air
prior to separation of oxygen and nitrogen.

- 36 -

4. A power plant of claim 3, wherein the substantially pure nitrogen is at least 95 percent nitrogen in the form of a gas.

5. A power plant of claim 1, wherein the substantially pure liquid oxygen is at least 95 percent oxygen.

6. A power plant of claim 1, wherein the substantially pure liquid oxygen is at least 99.5 percent oxygen.

10 7. A power plant of claim 1, wherein about 5 percent of the recovered carbon dioxide is liquefied for removal from the plant.

8. A power plant of claim 1, wherein about 95 percent of the recovered carbon dioxide is recycled for
15 passage through said gas turbine.

9. A power plant of claim 1 in a steady state operation, wherein an amount of carbon dioxide equal to 100 percent of the carbon dioxide produced from combustion is liquefied for removal from the plant.

20 10. A power plant of claim 1, wherein said air separation unit comprises a cooler arranged to cool the air prior to separation of oxygen, a compressor arranged to pressurize the air prior to separation of oxygen, and a distillation tower arranged to separate the oxygen from
25 the air.

11. A power plant of claim 1, wherein said carbon dioxide removal unit comprises a compressor arranged to pressurize the remainder of the recovered carbon dioxide

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US95/11018

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) : F02C 6/00

US CL : 60/39.02, 39.07

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 60/39.02, 39.07, 39.12, 39.33, 39.461, 39.465, 39.52

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, A, 4,434,613 (STAHL) 06 MARCH 1984, see entire document	1-23
A	US, A, 4,528,811 (STAHL) 16 JULY 1985, see entire document	1-23
A	US, A, 4,974,412 (SCHNEIDER) 04 DECEMBER 1990, see entire document	1-23
A	US, A, 5,388,395 (SCHARPF ET AL) 14 FEBRUARY 1995, see entire document	1-23

☐ Further documents are listed in the continuation of Box C. ☐ See patent family annex.

* Special categories of cited documents:	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be of particular relevance	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E" earlier document published on or after the international filing date	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

07 NOVEMBER 1995

Date of mailing of the international search report

17 JAN 1996

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. NOT APPLICABLE

Authorized officer

LOUIS J. CASAREGOLA

Telephone No. (703) 308-1027

- 37 -

gas, a filter arranged to remove water vapor from the remainder of the recovered carbon dioxide gas, a cooler arranged to cool the remainder of the recovered carbon dioxide gas, and a condenser arranged to liquefy the
5 remainder of the recovered carbon dioxide gas using the liquid oxygen as a cooling source.

12. A power plant of claim 1, further comprising a compressor arranged to pressurize the liquid oxygen from said distillation column prior to directing
10 the liquid oxygen to said carbon dioxide removal unit to liquefy the remainder of the recovered carbon dioxide gas; and

a heat exchanger arranged such that the cold oxygen gas from said air separation unit is used to cool
15 the recycled carbon dioxide gas prior to passage of the carbon dioxide gas through said gas turbine.

13. A power plant of claim 3, further comprising a compressor arranged to pressurize the liquid oxygen from said distillation column prior to directing
20 the liquid oxygen to said carbon dioxide removal unit to liquefy the remainder of the recovered carbon dioxide gas; and

heat exchangers arranged such that both the cold oxygen gas and the cold nitrogen from said air separation
25 unit are used to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide gas through said gas turbine.

14. A power plant of claim 12, wherein said liquid oxygen is pressurized to a pressure of at least 17
30 bar.

- 38 -

15. A power plant of claim 12, further comprising a heat recovery steam generator arranged to produce steam and a flue gas using the exhaust gas from said gas turbine as a heat source, and further arranged to heat
5 the cold oxygen gas produced by liquefaction of the remainder of the recovered carbon dioxide gas, prior to passage of the oxygen into said gas turbine.

16. A method of generating electricity with virtually zero pollutant emissions in a power plant
10 having a gas turbine, said method comprising
arranging the gas turbine to combust a fuel in the presence of substantially pure oxygen gas and carbon dioxide gas, and to produce an exhaust gas consisting essentially of water and carbon dioxide;
15 recovering carbon dioxide gas from the exhaust gas;
recycling a first portion of the recovered carbon dioxide gas for passage through the gas turbine;
separating oxygen from air and producing a stream
20 of substantially pure liquid oxygen;
directing said substantially pure liquid oxygen to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide through the gas turbine, and to liquefy a remaining portion of the recovered carbon
25 dioxide gas for removal from the plant, the liquid oxygen thereby evaporating and forming oxygen gas; and
directing the oxygen gas to the gas turbine.

17. A method of claim 16, wherein the fuel is natural gas, liquefied natural gas, or synthesis gas.

30 18. A method of claim 16, further comprising the steps of

- 39 -

separating nitrogen from the air and producing a stream of cold, substantially pure nitrogen; and

directing the cold nitrogen to cool the recycled carbon dioxide gas prior to passage of the carbon dioxide
5 gas through said gas turbine, and to cool the air prior to separation of oxygen and nitrogen.

19. A method of claim 16, further comprising the steps of

compressing the substantially pure liquid oxygen
10 prior to evaporation of the liquid oxygen during liquefaction of the remaining portion of the recovered carbon dioxide gas, thereby forming cold oxygen gas; and
heating the cold oxygen gas after directing the cold oxygen gas to cool the recycled carbon dioxide gas,
15 and prior to passage of the oxygen gas into said gas turbine.

20. A method of claim 16, wherein about 95 percent of the recovered carbon dioxide gas is recycled, and about 5 percent of the recovered carbon dioxide gas
20 is liquefied for removal from the plant.

21. A method of claim 16, wherein during steady state operation, an amount of carbon dioxide equal to 100 percent of the carbon dioxide gas produced from combustion is liquefied for removal from the plant.

22. A method of claim 16, wherein the exhaust gas
25 contains less than 100 parts per million by volume of nitrogen oxides.

23. A power plant of claim 1, wherein the exhaust gas contains less than 100 parts per million by volume of
30 nitrogen oxides.

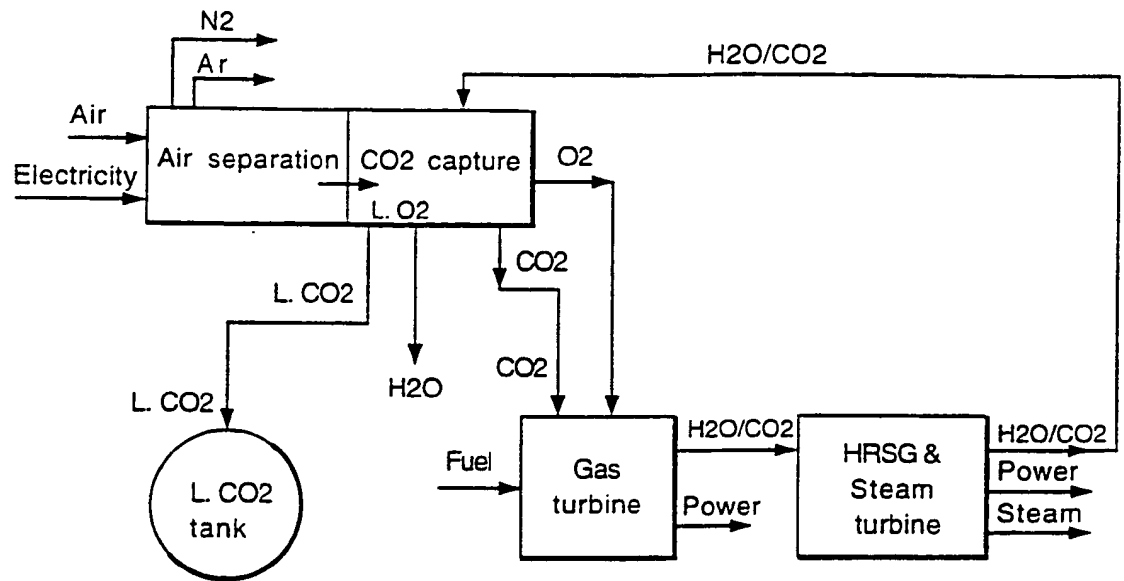


FIG. 1

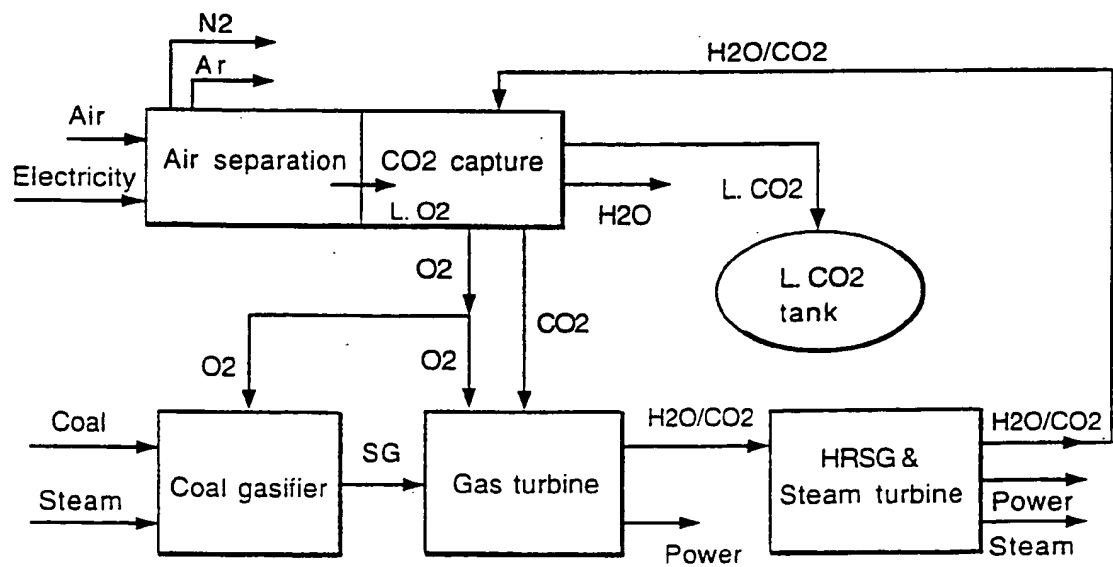


FIG. 2

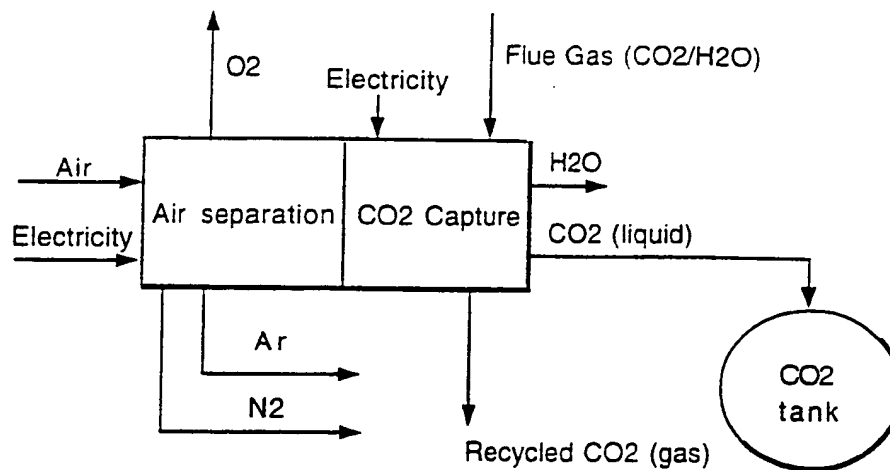


FIG. 3

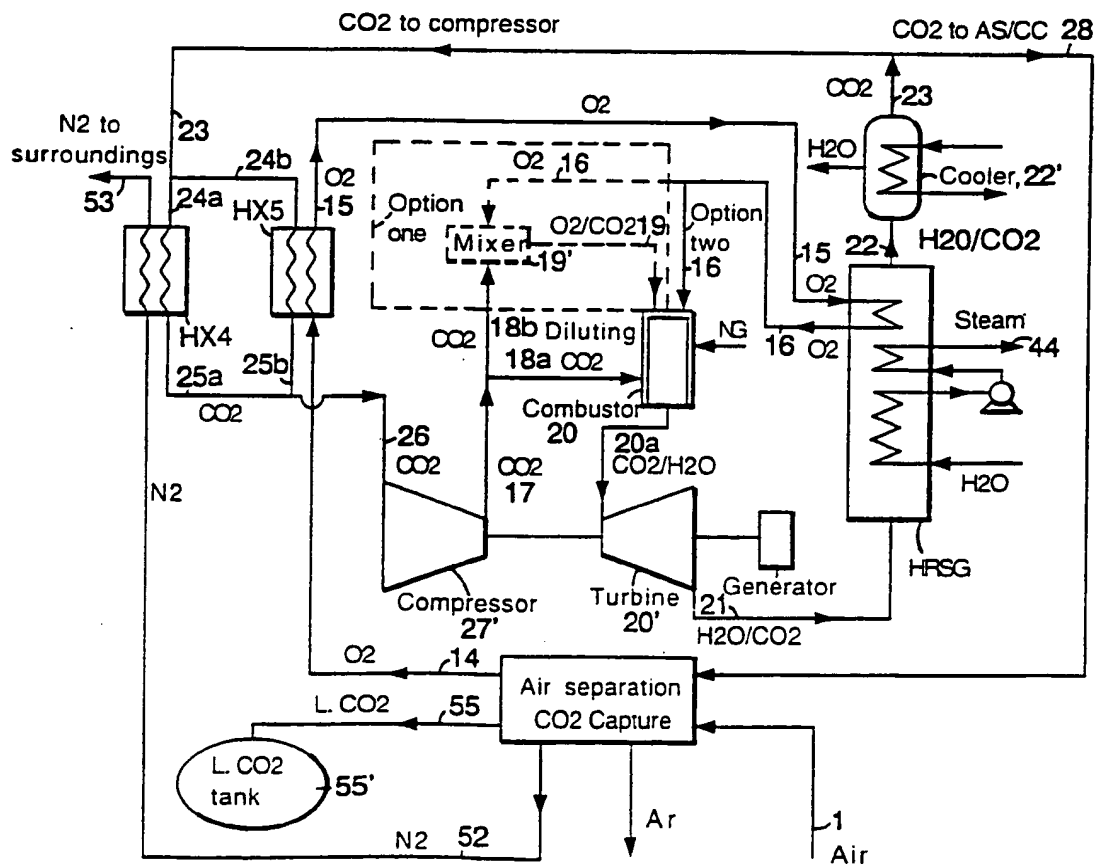


FIG. 4

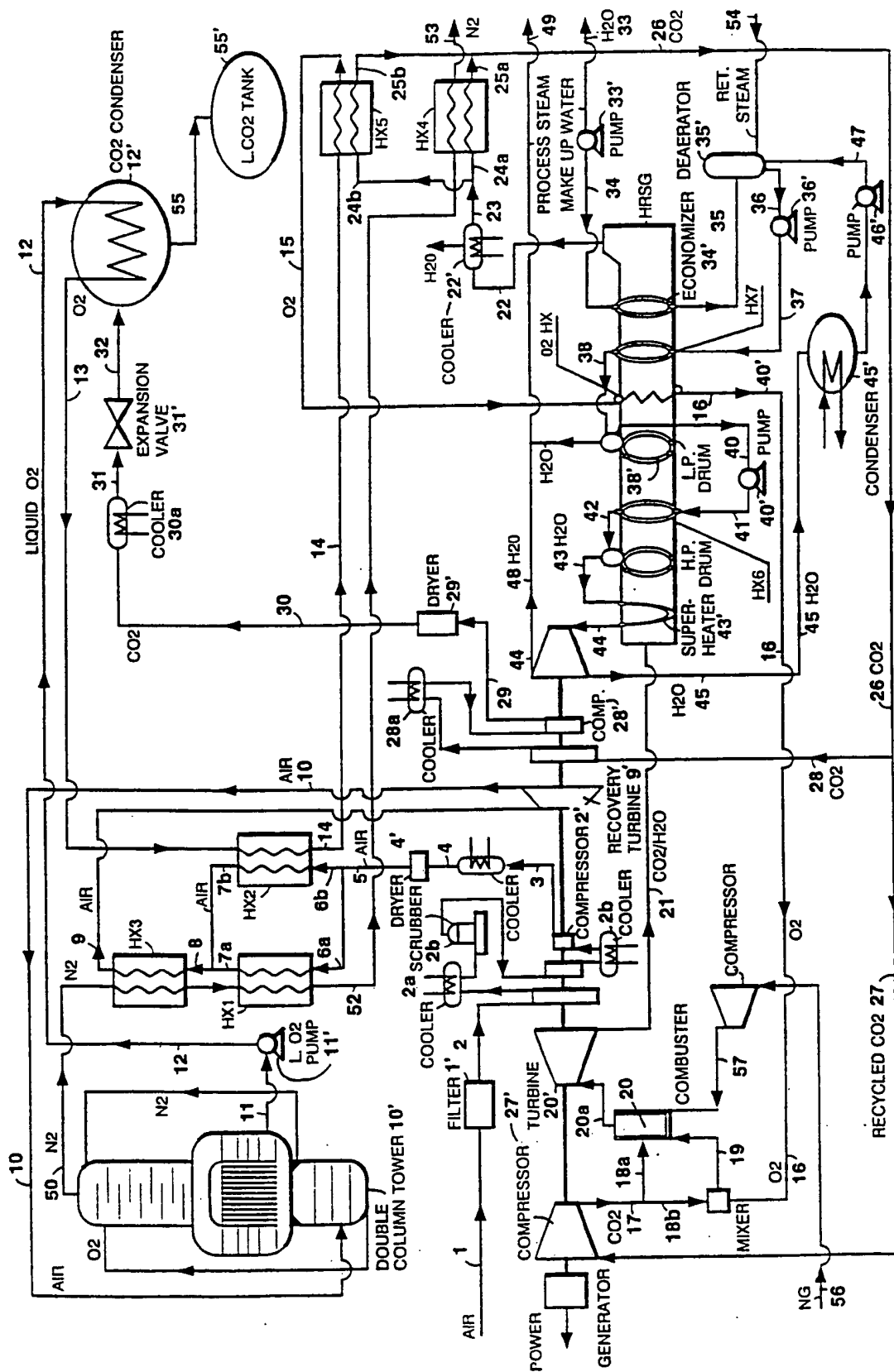


FIG. 5